

Process Sheet

1 Dart Helicopters Services

Drawing Name : AFT BLADE FOLD ASSEMBLY

: 09/02/2009 S.O. No. :

: NC

: //

Type : SMALL /MED FAB

: 43065

Part Number : PB674300103

Drawing Number : B6743001 P.1,3,4,15

Project Number : N/A

Drawing Revision : B1

Material :

Due Date : 18/03/2009 Qty: 2 Um: Each

Written By :

Checked & Approved By :

Comment :

: Est Rev:A 08-07-30 new issue DD verified by:ec

: Est Rev:B 08-12-04 up date part list DD Verified by:ec

Additional Product

Job Number:

Seq. #:

Machine Or Operation:

Description :

1.0

PB674300109

Aft Blade Fold Assembly Weldment

Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Aft Blade Fold Assembly Weldment

batch: _____

B45047

MF 09-03-10

2.0

PB674300113

Aft Adjustable Blade Support Assembly

Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Aft Adjustable Blade Support Assembly

batch: _____

B45042

MF 09-03-10

3.0

PB674300117

Aft Adjustable Blade Support Assembly

Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Aft Adjustable Blade Support Assembly

batch: _____

B45040

MF 09-03-10

4.0

PB674300121

PB67-43001-21

Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

PB67-43001-21

batch: _____

45038

MF 09-03-10

5.0

PB674300123

PB67-43001-23

Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

PB67-43001-23

batch: _____

B45035

MF 09-03-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 09/02/2009 4:27:15 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 45645

Part Number: PB674300103

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	PB674300137	PB67-43001-37
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

PB67-43001-37

batch: 45029

MF 09-03-06

7.0	PB674300157	Stabilizer Arm
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Stabilizer Arm

batch: 45025

MF 09-03-06

8.0	PB674300159	PB67-43001-59
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

PB67-43001-59

batch: 43054 x 1, 45024

MF 09-03-06

9.0	PB674300163	Handle Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Handle Assembly

batch: B43053 x 1

* B 45023

MF 09-03-

10.0	PB6743001135	Male Eye
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Male Eye

batch: 23995A

MF 09-03-04

11.0	PB6743001155	Pin
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pin

batch: B 40577 x 1, 41906 x 1

MF 09-03-04

12.0	PB6743001261	Lever Arm
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Lever Arm

batch: 42093

MF 09-03-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 45645

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PB6743001265

Bushing



10.000



PK

Comment: Qty.: 5.0000 Each(s)/Unit Total: ~~8~~0000 Each(s)

Bushing

batch: 44977

MF 09-03-04

14.0

PB6743001299

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bushing

batch: B 40062

MF 09-03-04

15.0

PB6743001305

Bearing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bearing

batch: B 41886

MF 09-03-04

16.0

D3451045

Handle and Lock-Down Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Handle and Lock-Down Assembly

batch: B 42996 x1, B 45309

MF 09-03-04

17.0

D3451043

Handle and Lock-Down Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Handle and Lock-Down Assembly

batch: B 45308 x1, 42348 x1

MF 09-03-04

18.0

D34401

Tube Guide (Supersedes B67-43001-25/-307)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Tube Guide

batch: 41347

MF 09-03-04

19.0

D34403

Clamp (Supersedes B67-43001-309)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Clamp




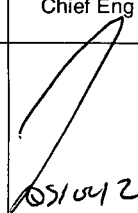

batch: ~~41347~~ B 39964

MF 09-03-04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: B67-43001-03 PAR #: PLA Fault Category: Prod / FAB LRG NCR: (Yes) No DQA: D Date: 09/03/12
 Resolution: SCRAP Disposition: Scrap QA: N/C Closed: D Date: 09/03/12

NCR: <u>45645</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09-03-10	13.0	1 - 265 scrap. Drill was damaged to the inside wall; the spring pin was sticking out on the inside R.C. Process		Scrap - replace Qty 1 B <u>44977</u>	 09-03-10		 09/04/12	 09-03-10

NOTE: Date & initial all entries

Date: Monday, 09/02/2009 4:27:16 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 45645

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

D34441

Velcro Loop Belt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Velcro Loop Belt

batch: B39965

mf 09-03-04

21.0

D34491

Pad



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pad

batch: B41617

mf 09-03-04

22.0

D34479

Swing Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Swing Arm

batch: 45018

mf 09-03-04

23.0

086004

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Inventory

batch: 10935

mf 09-03-04

24.0

MS27039107

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: m18057 *

mf 09-03-04

25.0

MS27039123

SCREW



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

SCREW

batch: m18057

mf 09-03-04

26.0

MS21042L4

Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total : 26.0000 Each(s)

Nut

batch: m109282

mf 09-03-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 45645

Part Number: PB674300103

Job Number:



Seq. #:	Machine Or Operation:	Description :
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27.0	MS21042L6	Nut
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

batch: m108183

MF 09-03-04

28.0	MS518596	WASHER
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

WASHER

batch: m108986

MF 09-03-04

29.0	MS518598	WASHER
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

WASHER

batch: m108986

MF 09-03-04

30.0	NAS43DD368	SPACER
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

SPACER

batch: m109060

MF 09-03-04

31.0	NAS1149F0316P	WASHER
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

batch: m109031

MF 09-03-04

32.0	NAS1149F0432P	Washer
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Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)

Washer

batch: m18057

MF 09-03-04

33.0	NAS1149F0632P	WASHER
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

WASHER

batch: m18057

MF 09-03-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 45645

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

NAS1149F0832P

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

batch: 18057

MF 09-03-04

35.0

AN960JD6

Washer



Comment: Qty.: 5 ¹⁰ 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: M10139 6085

MF 09-03-04

36.0

AN410A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

batch: M107178

MF 09-03-04

37.0

AN413A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: M110865

MF 09-03-04

38.0

AN416A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

batch:

or AN415A (see engineering) batch: M110399

MF 09-03-04

39.0

AN611A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

batch: M105558

MF 09-03-04

40.0

AN620A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

batch:

or AN6C16A (see engineering) batch: M105831

MF 09-03-04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Date: Monday, 09/02/2009 4:27:16 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 45645

Part Number: PB674300103

Job Number:



Seq. #:	Machine Or Operation:	Description :
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41.0	AN813A	BOLT
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
BOLT
batch: m18180

mf 09-03-05

42.0	BSP43	RIVET
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)
RIVET
batch: m109119

mf 09-03-05

43.0	CR3213405	cherry rivet
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
cherry rivet
batch: m104214

mf 09-03-05

44.0	MS17984C413	PIN, QUICK RELEASE
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
PIN, QUICK RELEASE
batch: _____
or MS17984C410 (see engineering) batch: m109739

mf 09-03-05

45.0	MS17984C418	PIN, QUICK RELEASE
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)
PIN, QUICK RELEASE
batch: m108986

mf 09-03-05

46.0	30345T21	LANYARD
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
LANYARD
batch: m102812

mf 09-03-05

47.0	30345T24	LANYARDS
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)
LANYARDS
batch: m111039

mf 09-03-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

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Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 45645

Part Number: PB674300103

Job Number:



Seq. #: Machine Or Operation: Description :

48.0 240107 SPRING SLOTTED PIN



lpl 24
ADD 4 TO INVENT



Comment: Qty.: 12.00 0000 Each(s)/Unit Total: 18.0000 Each(s)

SPRING SLOTTED PIN

batch: 1850 → 28 m11068 → 6

MF 09-03-05

49.0 3408A98 DETENT BALL SPRING PLUNG



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

DETENT BALL SPRING PLUNG

batch: m108390

MF 09-03-05

50.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per dwg and use 242 threadlock A/R shown on dwg PB67-43001 page 2

242 THREADLOCK batch: m109687

MF 09/03/11
lpl 09-03-11
(X2)

51.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09-03-11 (2)

52.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PAP 45606
09/3/12 (2)

53.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/12

Job Completion



MF 09-03-12

↳ Add detail A:

ANS26A x2 B M18057 lpl
NAS114F0532P x 4 B M18057 lpl
ms2104225 x 2 B M110382 lpl
ms246945102 x 4 B M14604 lpl
ms51859-7 x 4 B M106421 lpl 09-03-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

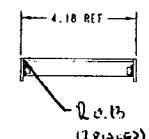
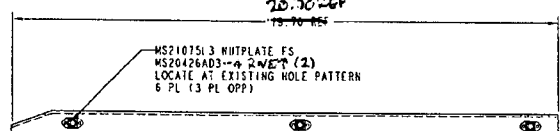
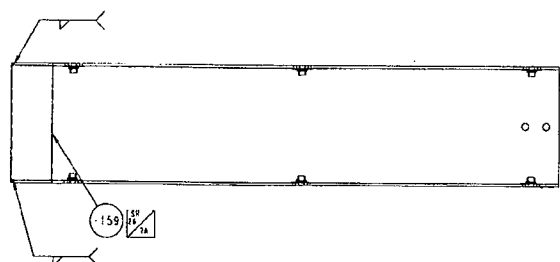
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

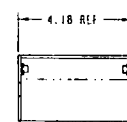
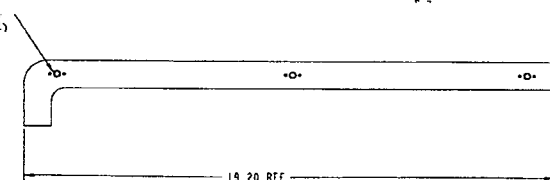
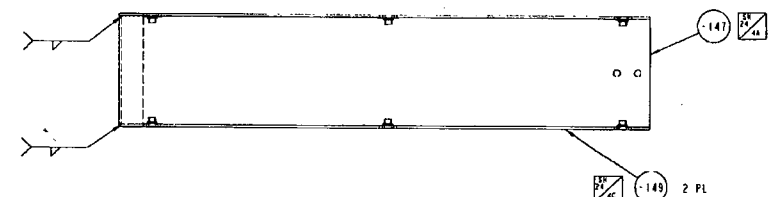
RELEASED

48645



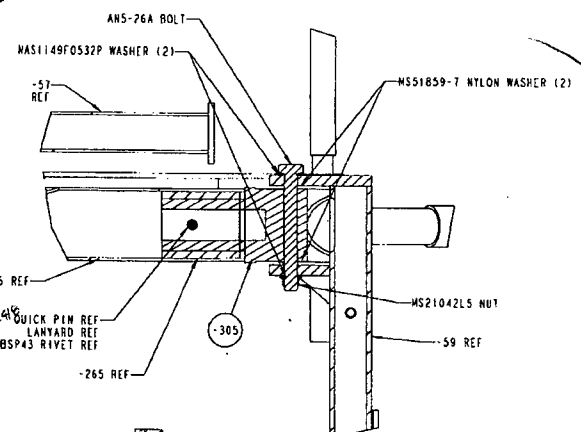
② -71 20 DEGREE BLADE SUPPORT ASSEMBLY

SCALE 0.500



② -67 90 DEGREE BLADE SUPPORT ASSEMBLY

SCALE 0.500



DETAIL A
SCALE 0.750
(-03 ASSY)

PREMIER AVIATION, INC.
2000 Aviation Parkway, Grand Prairie, Texas 75002
D105UV8 867-43001

ORIGINAL

